

Work Order ID 68687

Wednesday, April 20, 2011 8:19:49 AM



Item ID: D350-591-113

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short

Start Date: 4/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 4/20/20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D2310	D
DSI 9525	A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-591-113

CHG005

8 wbrlog

110

0.00



Large Fab

Large Fab

Memo

0.00

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310
2-Drill extrusion as per Dwg D2310 using drill Jig DT8230
3-Deburr

11.05.09

6 *Ø*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Sequence ID/
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Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 x 6.5/10



130

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Weld Fwd end cap and bushing as per Dwg D2310

A/R AL ROD Batch: m114703 m115928

2-Grind end cap and bottom bushing welds flush

3-Machine top weld on bushing flush

11.05.10 6



11.05.16

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

6 0 11/05/17

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Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11.05.17 (6)

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11.05.17

170

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Rivet as per Dwg D2310

2-Inspect for foreign object as per QSI 024

3-Weld Aft end cap as per Dwg D2310

A/R AL ROD Batch: M114703

4-Grind end cap welds flush

11.06.02
A.E. 11.06.02

11.06.01 (6)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

S ul-6/6/07

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S ul-6/6/07

(x6)

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6x Ø m-14/6/08

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

11:50
START TIME: 11:50
OVEN TEMPERATURE: 320
FINISH TIME: 12:20

0.00

Powder Coating

220

Wing Walk as per dwg QSI005 4.4 Batch 117863

0.00



HandFinish

Memo

0.00

Hand Finishing

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6X 0 M-11/06/09

6 0 BK 11-6-13

6 0 M 11/06/13

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/6/10

250

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S. U. 10/10

11/6/10

260

PACKAGING RESOURCE #1

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-113

Location: 80 Reun

11/6/10

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11 *[Signature]*ME
11-07-07

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, April 20, 2011 8:19:57 AM

Page 1

Work Order ID: 68687

Parent Item: D350-591-113

Parent Item Name: Heli-Access-Step, Short

Start Date: 4/20/2011

Required Date: 6/24/2011


Start Qty: 6.00

Required Qty: 6.00


Comments: IPP Rev:H 04.11.09 Reformat KJ/JLM
ECN10-586 10.06.18 DD verf:EC

IPP Rev:E as per


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116  Step Extrusion		Manufactured	No			110	Each	158.0000	1	6		11.05.09	
---	--	--------------	----	--	--	-----	------	----------	---	---	--	----------	--

Location	Loc Qty	Loc Code
HALL	94	
60307	94	
WA	64	
57850	18	
60307	46	

D2275  Bushing		Manufactured	No			130	Each	29.0000	1	6		11.05.13	
--	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA015	29	
27755	29	

D2673-34  End Plate		Manufactured	No			130	Each	101.0000	2	12		11.06.03	
---	--	--------------	----	--	--	-----	------	----------	---	----	--	----------	--

Location	Loc Qty	Loc Code
WA015	101	
59690	101	

6+6

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, April 20, 2011 8:19:57 AM

Page 2

Work Order ID: 68687

Parent Item: D350-591-113

Parent Item Name: Heli-Access-Step, Short

Start Date: 4/20/2011

Required Date: 6/24/2011

Start Qty: 6.00

Required Qty: 6.00

D2582

Manufactured No

170

Each

8.0000

1

6



Step Leg Assembly



11.06.01

Location

Loc Qty

Loc Code

WA014

8

62053

2

67214

6

MS20600-AD4W3

Purchased

No

170

Each

841.0000

16

96



Cherry Rivets



11.06.03

Location

Loc Qty

Loc Code

ST321

420

111636

420

WA018

421

107939

421

K591-113

Manufactured

No

240

Each

0.0000

1



Short Step Instln Kit



96
168295 11/7/05

Wednesday, April 20, 2011 8:19:58 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2310	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68687

D/11-041-20

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16

*cut per drawing

RELEASED
05.11.28 *[Signature]*

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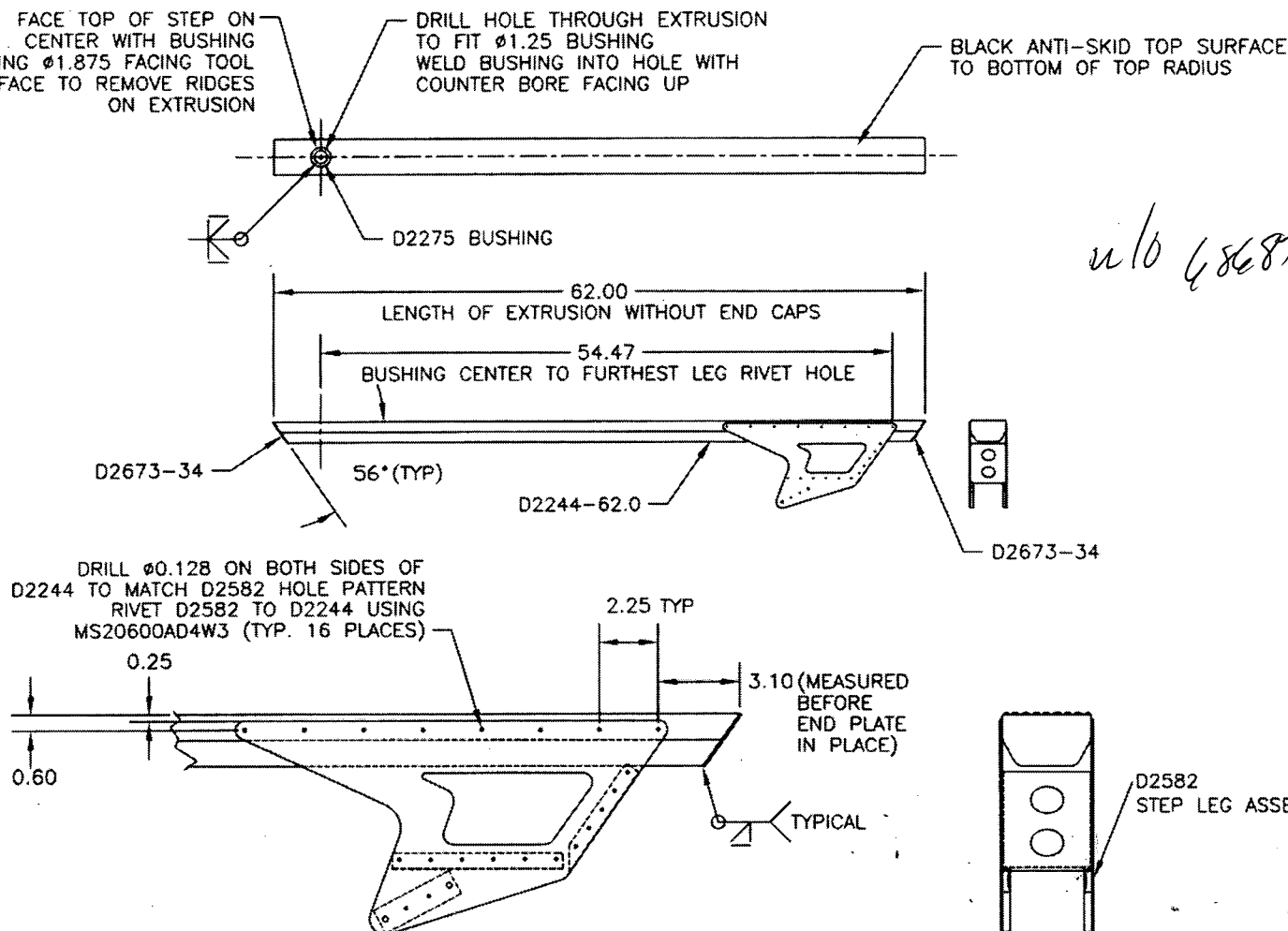
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DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.11.14		D2310
DATE	TITLE	SCALE
	HIGH SHORT STEP ASSEMBLY	NTS
		SHEET 2 OF 2
		REV. D



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3

REF TCCA STC: SH92-6

REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 *Heli-Access-Step™* (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:






QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step – Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

W/068687

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STEP CUSHION CHANGE	NTS
DATE	10.06.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

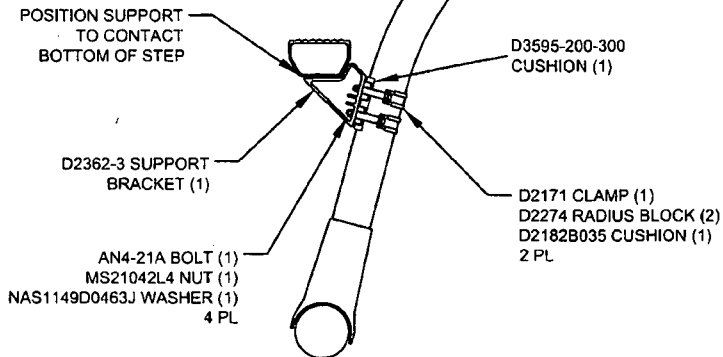
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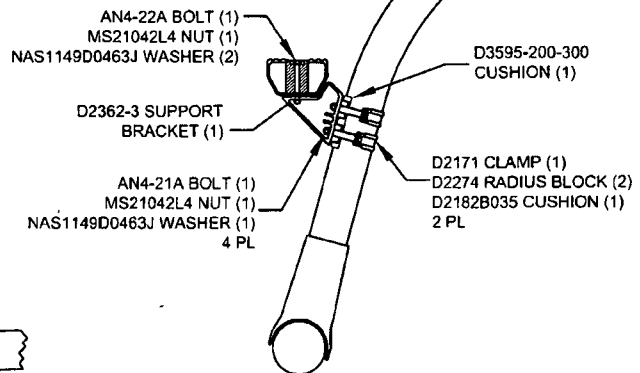
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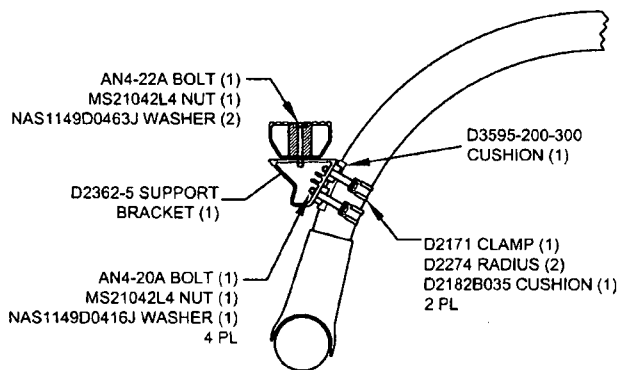
NOTE: Date & initial all entries



SECTION C-C: CENTER SUPPORT
(D350-591-111A ONLY)
(NOT TO SCALE)



SECTION D-D: AFT ATTACHMENT
(D350-591-111A/-113/-119 ONLY)
(NOT TO SCALE)



SECTION E-E: AFT ATTACHMENT
(D350-591-115 ONLY)
(NOT TO SCALE)

u/o 68687

FIGURE 32-9: Crosstube Attachment
REF ICA-D350-591





FIGURE 9: Crosstube Attachment
REF D350-591

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	90	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STEP CUSHION CHANGE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

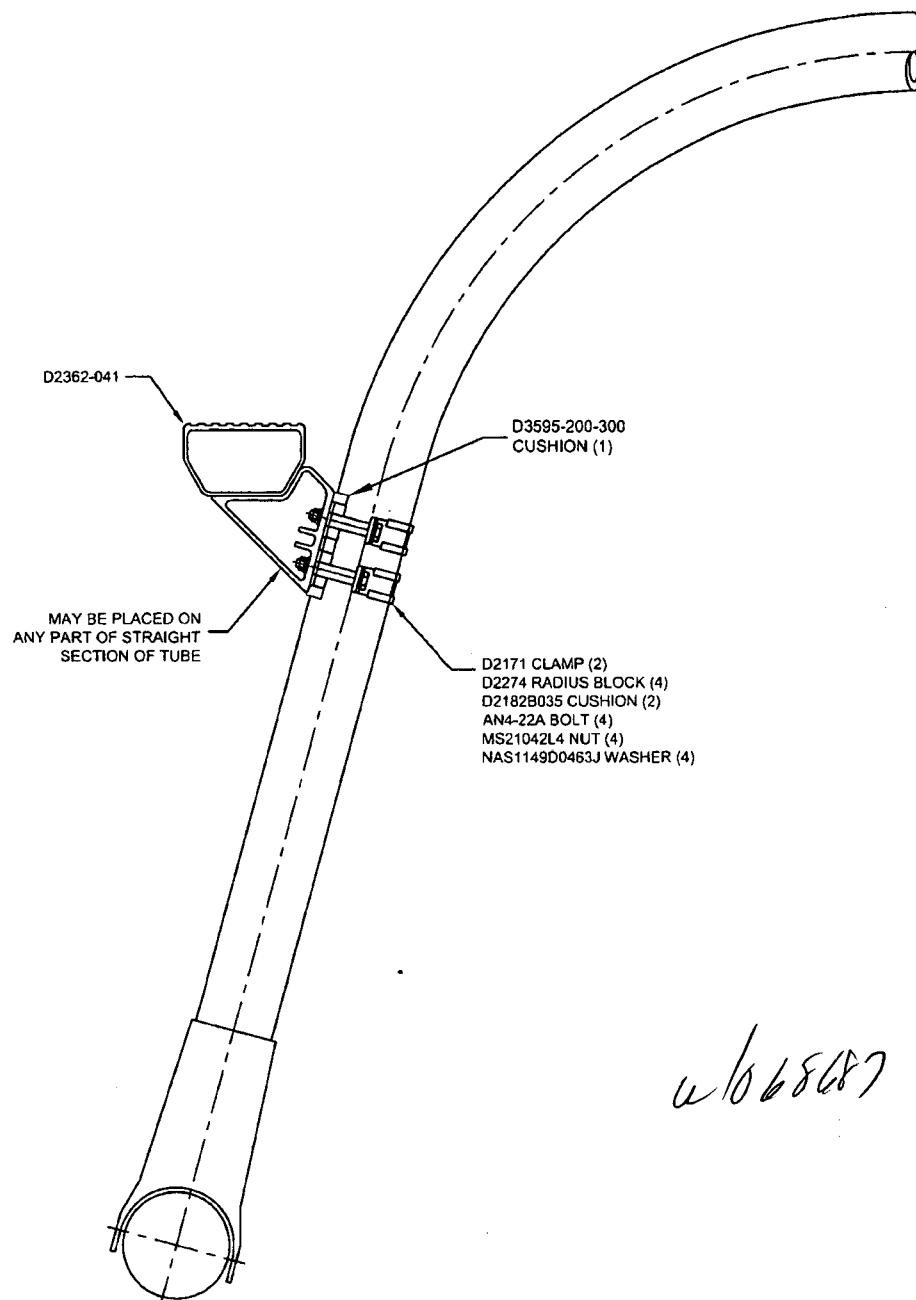


FIGURE 32-10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF ICA-D350-591

FIGURE 10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF D350-591

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries